

Work Order ID 113529

February-20-14 7:39:57 AM

113529

Page 1

Item ID: D412-711-101 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Vertical Reference Window
 Start Date: 2/27/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 2/27/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 14-02-20 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-711-101	B								
100		0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefiles and create labels for PPP D412-711-101 Change 002								
110		0.00							
110	HAND FINISHING THERMOFORMING								
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Set up Machine as per folio FTA 077 and D711W program using mould DT9640								
120		0.00							
120	HAND FINISHING THERMOFORMING								
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Cut Blanks to 37.5" by 43"								

MLJ 14-02-24
 x2 C Dh
 14/02/20

x2 Wh
 14/02/21

2 B 14/02/21

Work Order ID 113529

February-20-14 7:39:57 AM

113529

Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	THERMOFORMING MACHINE					2			B 14/02/21
Thermoform	Memo	0.00							
Thermoforming Machine	Thermoform as per Dwg. D412-711-101 using DT 9640 and Folio FTA 077								
	Dwg. Rev. <u>B</u>								
	Folio Rev. <u>B</u>								
	Visually inspect for proper formation and clarity								
	Visually and inspect magic eye								
	Verified by: <u>B</u>								
160		0.00							
160	HAND FINISHING THERMOFORMING					2			B 14/02/21
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	1) Trim off excess flange material								
	2) Buff out any light scratches or blemishes								
	3) Etch part number and batch number								

Work Order ID 113529

February-20-14 7:39:57 AM

113529

Page 3

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Required Date: 2/27/14 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC2- Inspect parts off machine FAI/FAIB	0.00							
170						2			14/02/23
QC	Memo	0.00							
Quality Control	1) Visually inspect for clarity, and proper formation.								
180	QC5- Inspect part completeness to step on W/O	0.00				2			
180									
QC	Memo	0.00							
Quality Control	1) Visually inspect for clarity, and proper formation.								
185	QC4- 100% Inspect kits for completeness	0.00							
185						2			
QC	Memo	0.00							
Quality Control									

SMP
4/2/24

DAS
6
3-89 11-2-27

Work Order ID 113529

February-20-14 7:39:57 AM

113529

Page 4

Item ID: D412-711-101

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Vertical Reference Window

Start Date: 2/27/14

Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/27/14

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: 090

0.00

190

Packaging

Memo

0.00

DAS

6

9-89

14-2-22[Signature]

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

14-02-28[Signature] 14-02-28

Picklist Print

February-20-14 7:39:57 AM

Page 1

Work Order ID: 113529

113529

Parent Item: D412-711-101

D412-711-101

Parent Item Name: Replacement Vertical Reference Window

Start Date: 2/27/14

Required Date: 2/27/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-02-01 JLM
Manufacture in-house 10/06/28 DL

IPP Rev. B.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MACRLICS.236

Purchased

No

sf

360.0000

43

MACRI ICS 236

Plexiglass G .236"

Location

Loc Qty

Loc Code

therm

360

M127669

160

M127867

200

43 *sf*

DL
17/07/14

DART AEROSPACE LTD		Work Order:	113529
Description: Replacement Window		Part Number:	D412-711-101
Inspection Dwg: D412-711-101	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____ "	1			
Shape Definition	1			
Texture Retention	1			
Material imperfections such as bumps, cracks, voids, scratching	1			

Measured by: BB

Date: 11/02/21

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00	+/-0.030	2.0	✓		TH-04	
1.98 N/A	+/-0.030				TH-04	
1.50	Min	1.625	✓		TH-01	
0.090	Min	.091	✓		ULTRA	
0.070	Min	.084	✓		ULTRA	
0.050	Min	.081	✓		ULTRA	
15.0	+/-0.5	.150	✓		TH-05	

Measured by: BB

Date: 14/02/23

Audited by: SMB

Date: 14/02/24

Preliminary Approval:

Date:

Rev	Date	Change	Revised by	Approved
B	10.10.08	New Issue	KJ	
C	13.06.03	Dimensions updated per Dwg Rev B	KJ	

